

Ship. 12 DEC

Work Order ID 154129

154129

Page 1

Monday, December 05, 2016 3:44:41 PM

Item ID: DSI 9506-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw Mod - Aerazur Float Compatibility

Start Date: 12/5/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: 16-12-5 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9506	B								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI 9506-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
21
9-89

16-12-06

DAS
28
9-89

DEC 12 2016

/ DEC 05 2016

DAS
6
9-89DAS
27
9-89DAS
28
9-89

DEC 12 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 154129

Monday, December 05, 2016 3:44:41 PM

154129

Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Mod - Aerazur Float Compatibility

Start Date: 12/5/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9506-011 Location: <u>Fg/22</u> PPP rev: _____								
140		0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS 28 9-89
DAS 27 9-89
DEC 12 2016

DEC 12 2016

DAS 21 9-89

DAS 21 9-89

DEC 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, December 05, 2016 3:44:46 PM

Page 1

Work Order ID: 154129

154129

Parent Item: DSI 9506-011

DSI 9506-011

Parent Item Name: Bearpaw Mod - Aerazur Float Compatibility

Start Date: 12/5/2016

Required Date: 12/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.18 verified by:JLM
16-11-10 AS PER DSI REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A

Purchased

No

110

Each

121.0000

4

4

AN4-12A

Bolt

**

DEC 05 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

111

m135704

111

D2274

Manufactured

No

110

Each

757.0000

4

4

D2274

Radius Block

**

DEC 05 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

442

150353

1

151763

441

ST012a

303

152449

303

D2529

Manufactured

No

110

Each

279.0000

4

4

D2529

Washer

**

DEC 05 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST008

279

150080

179

153945

100

DAS
28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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				Lead hand / Supervisor Approval Verification	
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Parent Item: DSI 9506-011

DSI 9506-011

Parent Item Name: Bearpaw Mod - Aerazur Float Compatibility

Start Date: 12/5/2016

Required Date: 12/12/2016

Start Qty: 1.00

Required Qty: 1.00

D3171-3 Manufactured No

110 Each 0.0000 4 4

D3171-3

Angle

MS21042L4

Purchased No

110 Each 2,734.000 4 4

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

196

m135058

196

OVER007

2000

m135979

500

m136182

500

m136295

1000

ST303

504

153851

85

m135864

419

NAS1149D0463J Purchased No

110 Each 3,379.000 4 4

NAS1149D0463.J

Washer

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST260a

1200

M136192

600

M136263

600

ST263

2099

M135671

3

M135948

496

M136044

1600

Monday, December 05, 2016 3:44:46 PM

Shop Packet Print

Page 2

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OTHER : _____					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. H AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 3 AND EARLIER

REF TCCA STC: SH93-4
REF FAA STC: SR00028NY / SR00029NY
REF EASA STC: 10016984
REF ARGENTINA STC: CTS-0508.13(A)
REF RUSSIA STC: CT107-350

SHOP COPY
RETURN TO
ISSUING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154129
16-12-05

To ensure compatibility between the D350-578-011/-013/-015/-017/-021 Bearpaw Installation and existing Aerazur Float System, customers are encouraged to procure DSI 9506-011 Installation Mod Kit listed below and perform the following deviations on installation. Refer to Figure 1.

1. Move each D2432F/D2432-3/D2672F/D4297-1/-3 Bearpaw aft by 1.50" max;
2. Substitute aftmost D2438 or D4011-1 Clamp with two D3171-3 Angles trimmed to fit the Aerazur Float Clamps on each D2432F/D2432-3/D2672F/D4297-1/-3 Bearpaw;
3. Add extra holes/counterbores (Ø0.260" thru, c bore Ø0.930" x 0.300" deep from bottom) on each D2432F/D2432-3/D2672F/D4297-1/-3 Bearpaw to mount center D2438 or D4011-1 Clamp to clear aft crosstube saddle.
4. If installing/re-installing D350-578-031 Wearplate Kit, replace center clamp hardware per Figure 1. Note: Hardware listed is customer supplied.

In all other aspects, install the D350-578-011/-013/-015/-017/-021 Bearpaw Installation per Installation Instructions D350-578 Rev. H or earlier.

PARTS LIST



QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9506-011	INSTALLATION MOD KIT
4	D2274	RADIUS BLOCK
4	D2529	WASHER
4	D3171-3	ANGLE
4	AN4-12A	BOLT
4	AN960JD416	WASHER
4	MS21042L4	NUT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	16.07.15
CERT. NO.:	SH93-4
ISSUE NO.:	10

B	GENERAL REVISION. REVISED APPLICABILITY AND D3171-3 WAS D3171-1. REASON: PAR14-380.	MB	16.07.15
A	NEW ISSUE	MB	10.02.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9506	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INSTALL MODIFICATION	NTS
DATE	16.07.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

IF INSTALLING/RE-INSTALLING D350-578-031
WEARPLATE KIT, REPLACE CLAMP HARDWARE
WITH FOLLOWING (CUSTOMER SUPPLIED) ITEMS:

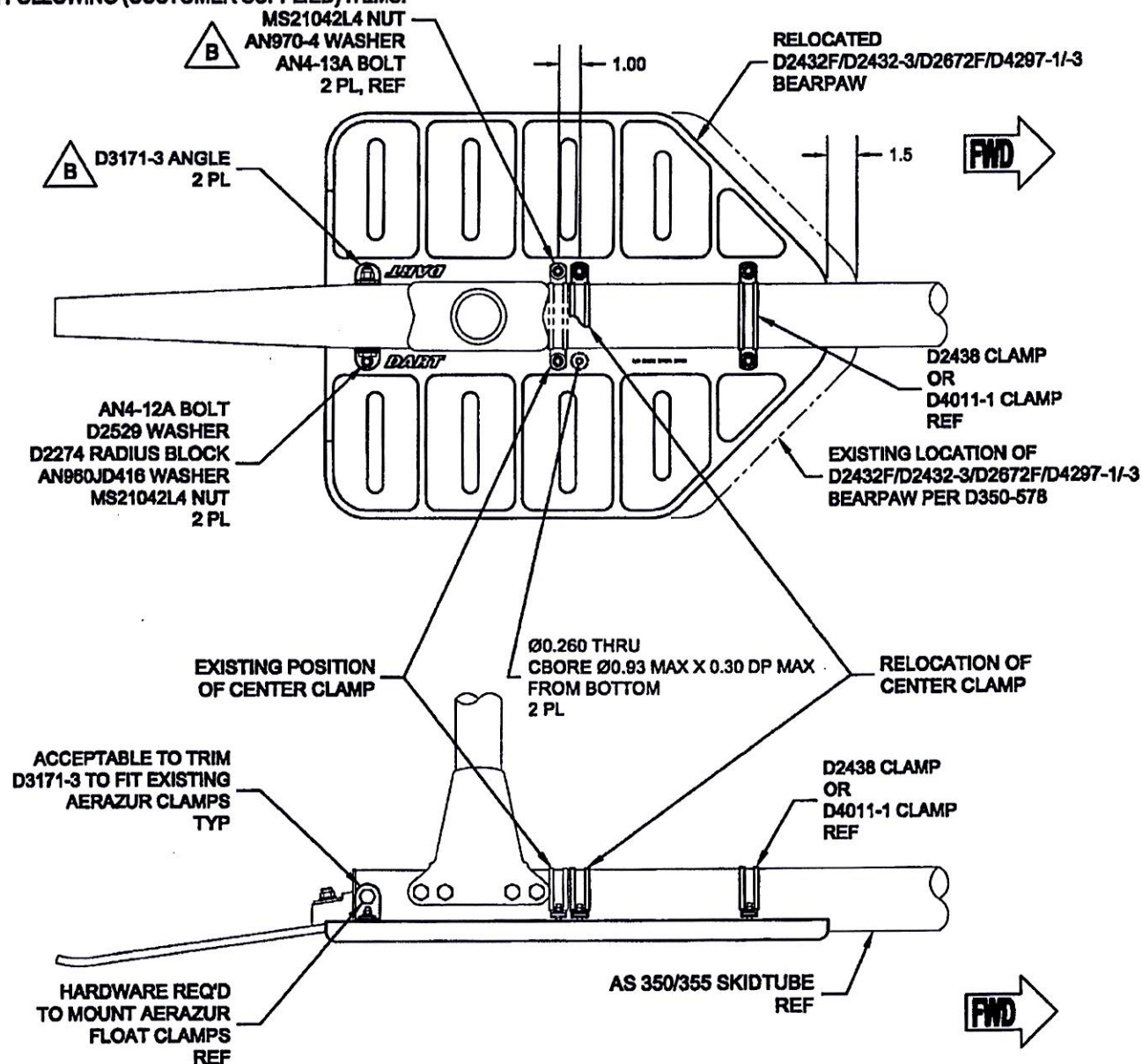


FIGURE 1: INSTALL MOD
(AERAZUR FLOAT AND HARDWARE NOT SHOWN FOR CLARITY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 16.07.15
CERT. NO.: SH03-4
ISSUE NO.: 10

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9506	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INSTALL MODIFICATION	NTS
DATE	16.07.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 154129***154129***

Page 1

Tuesday, December 06, 2016 10:01:31 AM

Item ID: DSI 9506-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Mod - Aerazur Float Compatibility

Start Date: 12/5/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9506	B

100	Document Control	0.00
-----	------------------	------

100

DC

Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI 9506-011
CHG001DAB
21
89

DEC 06 2016

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Memo 0.00

Packaging

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC

Memo 0.01

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. H AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 3 AND EARLIER

REF TCCA STC: SH93-4

REF FAA STC: SR00028NY / SR00029NY

REF EASA STC: 10016984

REF ARGENTINA STC: CTS-0508.13(A)

REF RUSSIA STC: CT107-350

To ensure compatibility between the D350-578-011/-013/-015/-017/-021 Bearpaw Installation and existing Aerazur Float System, customers are encouraged to procure DSI 9506-011 Installation Mod Kit listed below and perform the following deviations on installation. Refer to Figure 1.

1. Move each D2432F/D2432-3/D2672F/D4297-1/-3 Bearpaw aft by 1.50" max;
2. Substitute aftmost D2438 or D4011-1 Clamp with two D3171-3 Angles trimmed to fit the Aerazur Float Clamps on each D2432F/D2432-3/D2672F/D4297-1/-3 Bearpaw;
3. Add extra holes/counterbores ($\varnothing 0.260$ " thru, bore $\varnothing 0.930$ " x 0.300" deep from bottom) on each D2432F/D2432-3/D2672F/D4297-1/-3 Bearpaw to mount center D2438 or D4011-1 Clamp to clear aft crosstube saddle.
4. If installing/re-installing D350-578-031 Wearplate Kit, replace center clamp hardware per Figure 1. Note: Hardware listed is customer supplied.

In all other aspects, install the D350-578-011/-013/-015/-017/-021 Bearpaw Installation per Installation Instructions D350-578 Rev. H or earlier.

PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9506-011	INSTALLATION MOD KIT
4	D2274	RADIUS BLOCK
4	D2529	WASHER
4	D3171-3	ANGLE
4	AN4-12A	BOLT
4	AN960JD416	WASHER
4	MS21042L4	NUT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i> BY: D. SHEPHERD (DE # 02)	
DATE: 16.07.15	
CERT. NO.: SH93-4	
ISSUE NO.: 10	

B	GENERAL REVISION. REVISED APPLICABILITY AND D3171-3 WAS D3171-1. REASON: PAR14-380.	MB	16.07.15
A	NEW ISSUE	MB	10.02.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9506	SHEET 1 OF 2
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